

Work Order ID 60171

June 28, 2010 1:00:08 PM

**PRELIMINARY ISSUE**

Page 1

Item ID: D3912-1

Accept



Setup Start



Revision ID:

Item Name: Eyebolt

Stop



Start Date: 28/06/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 29/06/2010 Req'd Qty: 1.00



Customer:



Reference:

Sub 10.06.28

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3912

APB 10/06/28

100

0.00



Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871 AND DWG

Prog Rev:

Dwg Rev:

Deburr as required

*SA 10/06/28**1 0*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*SA 10/06/28**1 0*

Work Order ID 60171

June 28, 2010 1:00:08 PM



Page 2

Item ID: D3912-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt

Start Date: 28/06/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 29/06/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspect to PB1 Dwg



QC

Memo

0.00

only
8/10/06/29 @

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

u/o B 60243

0.00

Memo

8/10/06/29

Packaging

10-08-23
PB1308

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

A conformity
PB1
released. Res B
10.07.23

Picklist Print

Page 1

June 28, 2010 1:00:07 PM

Work Order ID: 60171



Parent Item: D3912-1

Parent Item Name: Eyebolt

Start Date: 28/06/2010

Required Date: 29/06/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000		Purchased	No			100	f	2.6800	0.25	0.263158			



303 ROUND BAR 2"



Location

Loc Qty

Loc Code

MAT029

2.68

113341

2.68

25 A SL 10/06/10

POSITIVE RECALL

EFFECTIVE 10-06-10 AUTH

RELEASED DATE ~~10-06-10~~

DART AEROSPACE LTD		Work Order: 60171
Description: Eyebolt		Part Number: A3912-1
Inspection Dwg: A3912	Rev: P13.1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

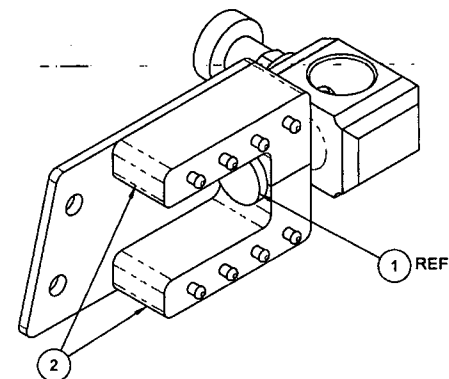
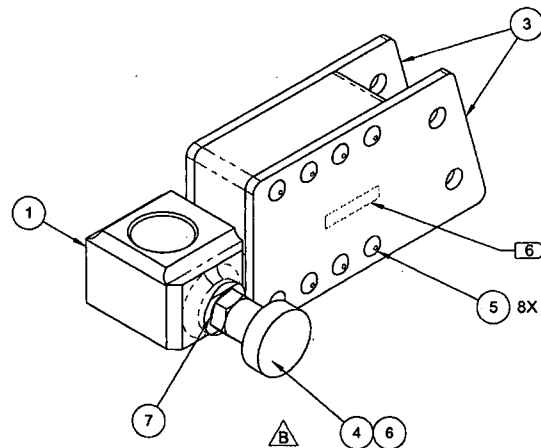
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.23	±.030	2.220	/			
1.20	±.030	1.192	/			
.625	±.010	.625	/			
.13	±.030	.143	/			
Ø.500	±.010	Ø.498	/			
Ø.700	±.010	Ø.700	/			
.90	±.030	.885	/			
.13 x .45	±.030	.110	/			
.22	±.030	.218	/			
.250	±.010	.248	/			
1.50	±.030	1.489	/			
.625	±.010	.625	/			
.44	±.030	.44	/			
Ø.650	±.010	Ø.650	/			
1.100	±.010	1.098	/			
Ø.719	±.010	Ø.723	/			
.11	±.030	.112	/			
.88	±.030	.880	/			
1.00	±.030	1.005	/			
.25	±.030	.25	/			

Measured by: SA	Audited by: S	Prototype Approval:	N/A
Date: 10/06/28	Date: 10/06/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

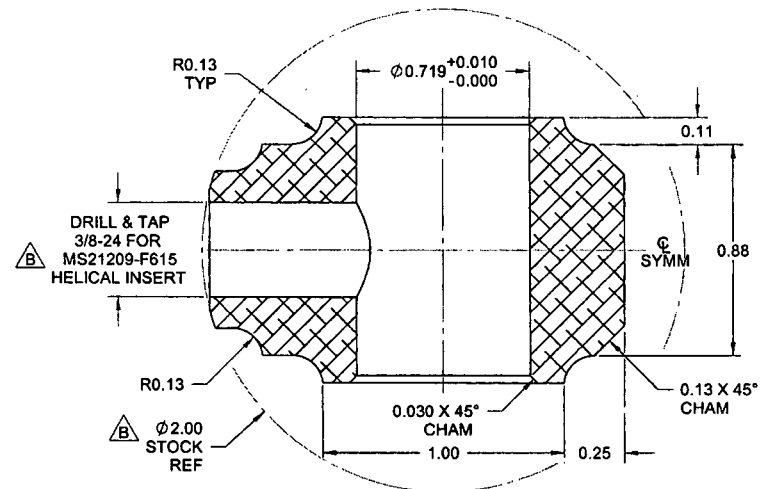
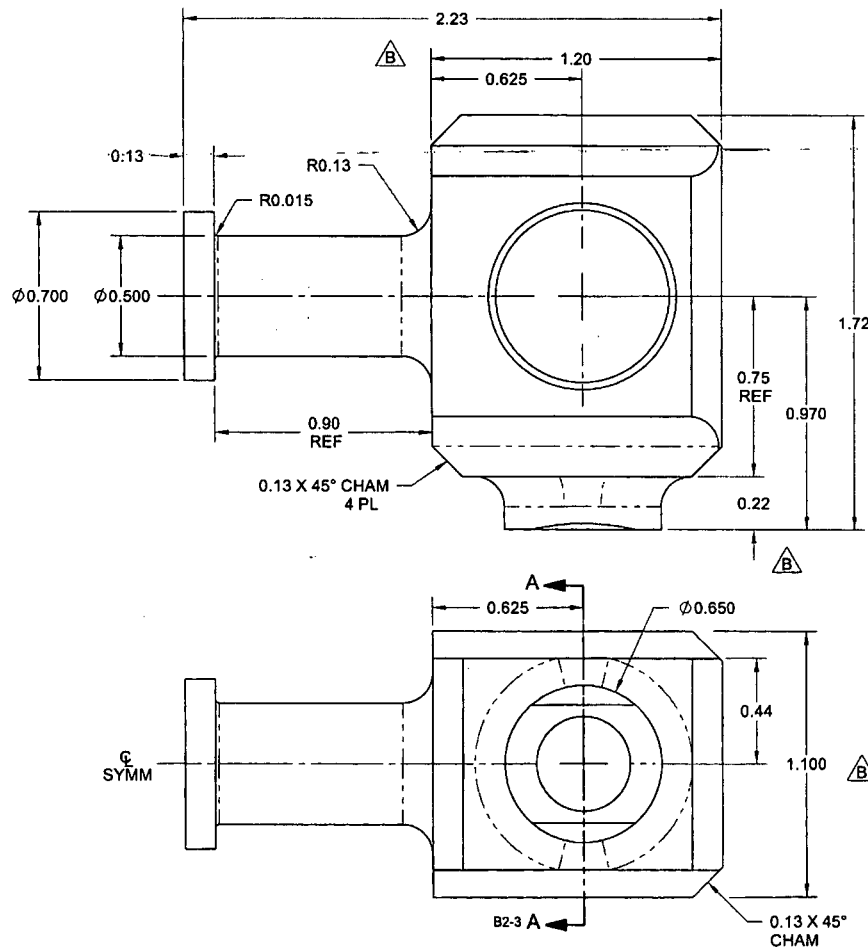
D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

RELEASED
2010-07-16

REV. B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-0810 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1.		JPH	10.06.28
REV. A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HLS		DART AEROSPACE LTD	
DRAWN	HLS		HAWKESBURY, ONTARIO, CANADA	
CHECKED	HLS		DRAWING NO. D3912	
MFG. APPR.	HLS		REV. B SHEET 1 OF 3	
APPROVED	HLS		TITLE EYEBOLT RECEIVER ASSY	
DE APPR.	HLS		SCALE NTS	
DATE	10.06.28		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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SECTION A-A B6-3

RELEASED
2010-07-16

D3912-1 EYEBOLT

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 REF DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ID AT ASSEMBLY
 - 7) WEIGHT: 0.45 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. D3912	REV. B
MFG. APPR.	JS	TITLE	SHEET 2 OF 3
APPROVED	JS	EYEBOLT RECEIVER ASSY	SCALE
DE APPR.	JS		NTS
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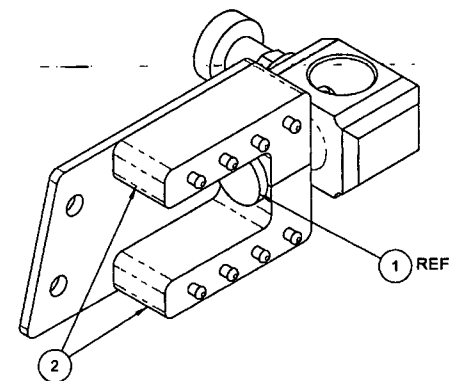
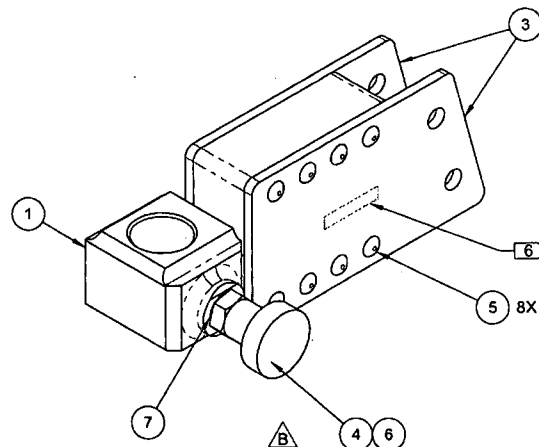


2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
 -5: 0.24 lbs

RELEASED
2010-07-16
amd

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>AS</i>	D3912	SHEET 3 OF 3
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	EYEBOLT RECEIVER ASSY	
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

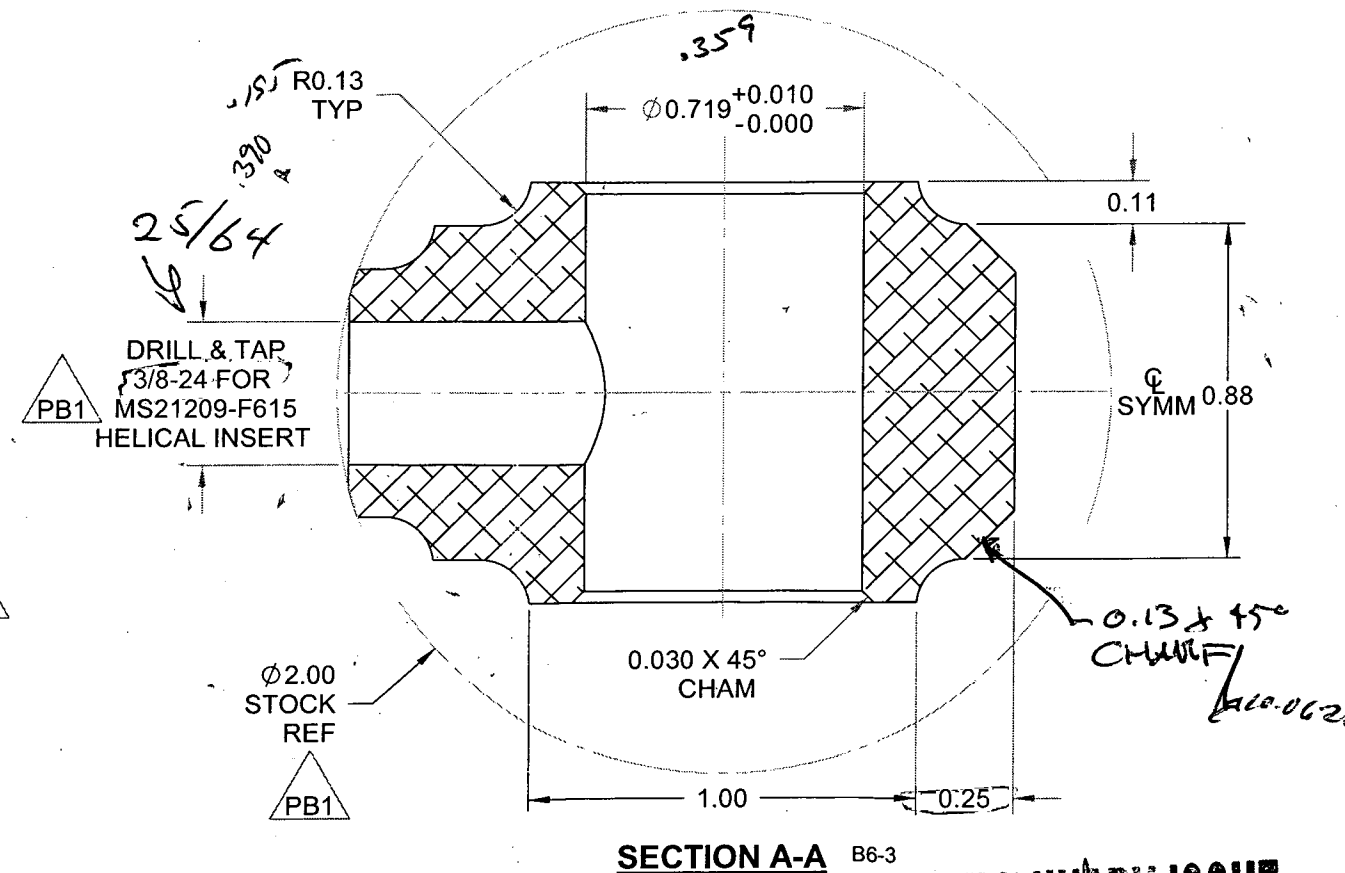
RELEASED
2010-07-16

B	D3801-1 WAS D3801-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0963R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1/5		
DRAWN	1/5		
CHECKED	1/5		
MFG. APPR.	1/5		
APPROVED	1/5		
DE APPR.	1/5		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

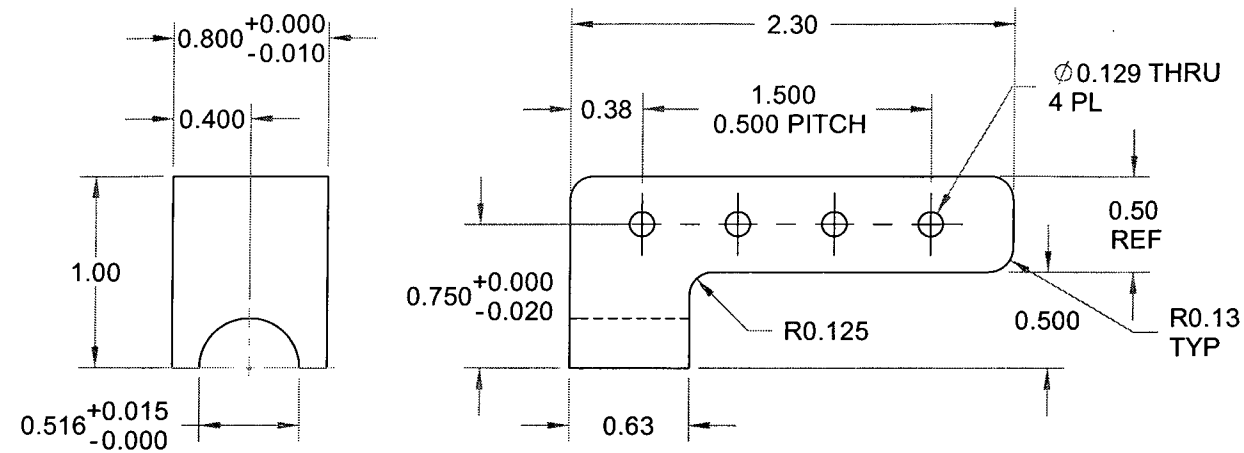
DRAWING NO. **D3912** REV. B
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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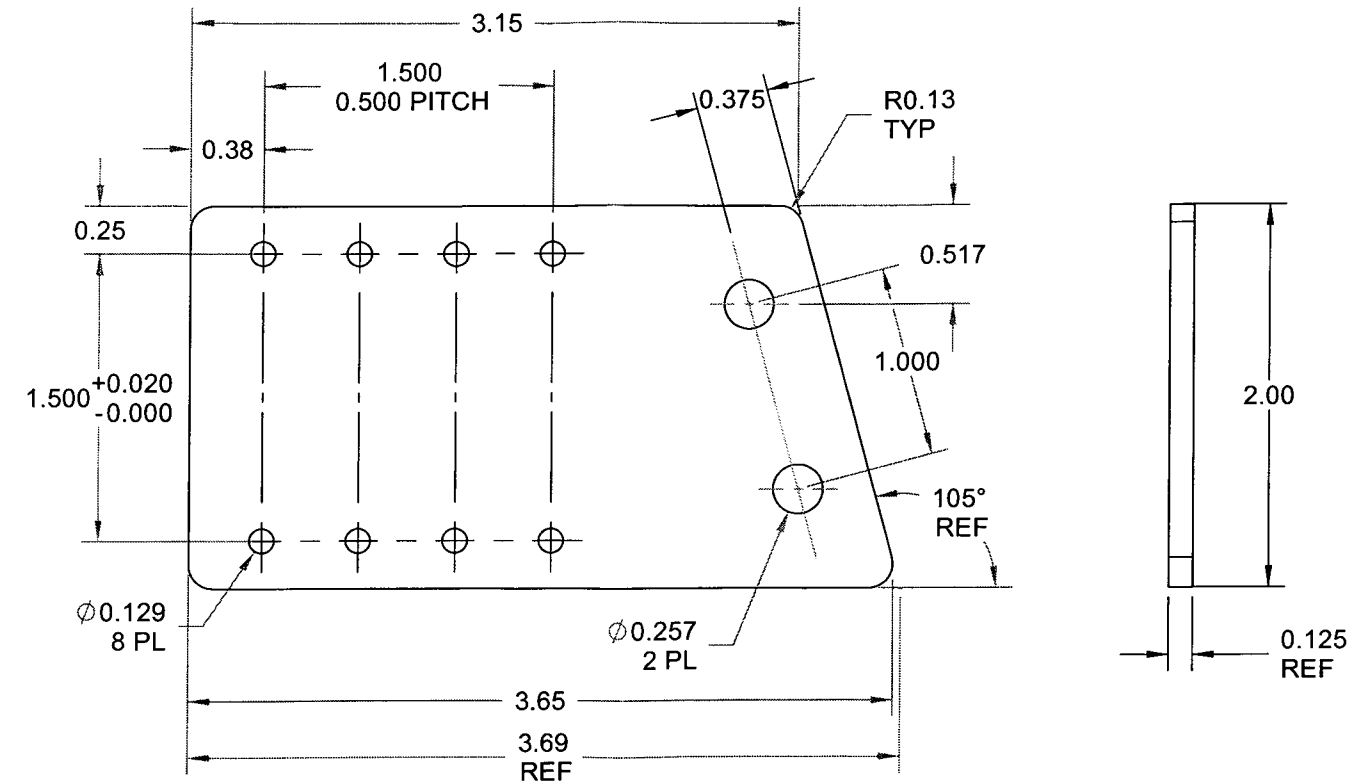


PRELIMINARY ISSU

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>gp</i>	DRAWING NO.	REV. PB
MFG. APPR.		D3912	SHEET 2 OF
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
DATE	10.04.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

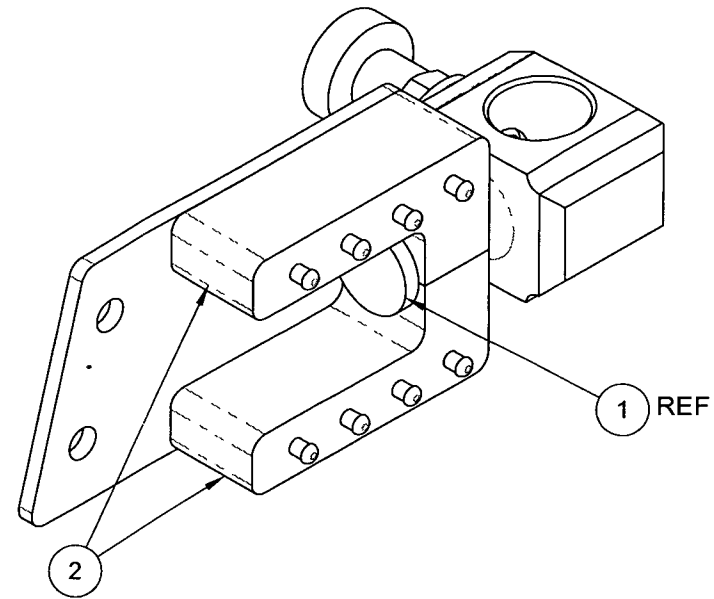
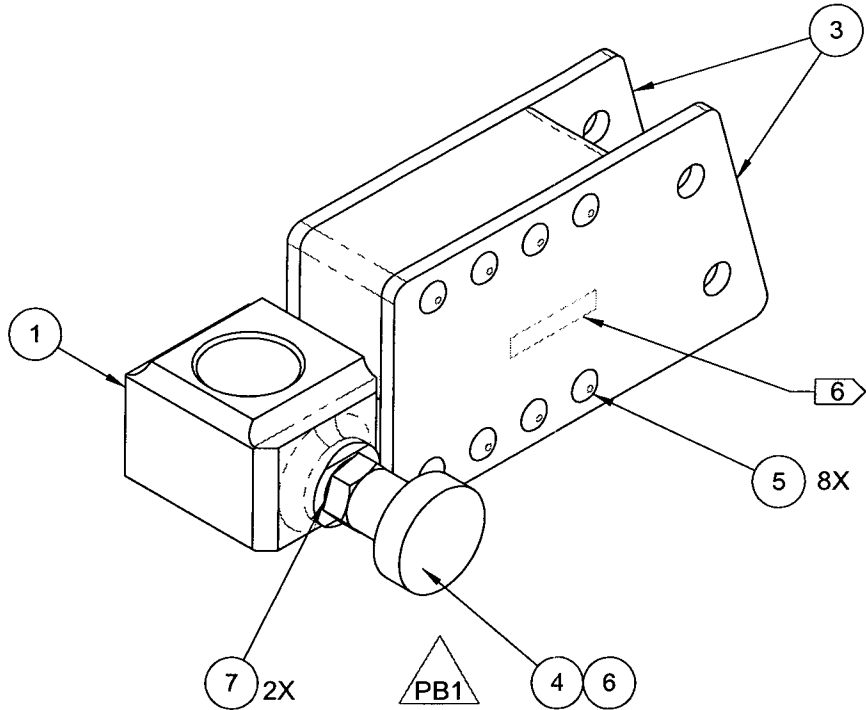
7) WEIGHT -3: 0.30 lbs

-5: 0.24 lbs

PRELIMINARY ISSUE
16.06.26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. PB1
MFG. APPR.		D3912	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
DATE	10.04.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

PRELIMINARY ISSUE

10.06.28

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.59 lbs

PB1	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (2X)WASHER NAS1149F0663P ADDED; BOSS ADDED TO D3912-1.	JPH	10.04.21
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. PB1
MFG. APPR.		D3912	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
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